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(54) Title: <b>BLEACHING COMPOUNDS COMPRISING SUBSTITUTED BENZOYL CAPROLACTAM BLEACH ACTIVATORS</b>			
(57) Abstract  Laundry detergents and bleaching systems which comprise substituted benzoyl caprolactam bleach activators are presented. The bleach activators are effective under mixed soil conditions, especially mixtures of hydrophobic and hydrophilic soils and stains.			

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BLEACHING COMPOUNDS COMPRISING SUBSTITUTED  
BENZOYL CAPROLACTAM BLEACH ACTIVATORS

FIELD OF THE INVENTION

The present invention relates to laundry detergents and bleaching systems which comprise novel substituted benzoyl caprolactam bleach activators.

BACKGROUND OF THE INVENTION

It has long been known that peroxygen bleaches are effective for stain and/or soil removal from fabrics, but that such bleaches are temperature dependent. At a laundry liquor temperature of 60°C, peroxygen bleaches are only partially effective. As the laundry liquor temperature is lowered below 60°C, peroxygen bleaches become relatively ineffective. As a consequence, there has been a substantial amount of industrial research to develop bleaching systems which contain an activator that renders peroxygen bleaches effective at laundry liquor temperatures below 60°C.

Numerous substances have been disclosed in the art as effective bleach activators. One widely-used bleach activator is tetraacetyl ethylene diamine (TAED). TAED provides effective hydrophilic cleaning especially on beverage stains, but has limited performance on dingy stains and body soils. Another type of activator, such as nonanoyloxybenzenesulfonate (NOBS) and other activators which generally comprise long chain alkyl moieties, is hydrophobic in nature and provides excellent performance on dingy stains. However, many of the hydrophobic activators developed thus far can promote damage to natural rubber parts used in certain washing machines and to natural rubber articles exposed to the activators. Because of these negative effects on natural rubber machine parts and articles, the selection of such detergent-added bleaching systems has been limited.

It has now been determined that in conventional bleaching systems, particularly those comprising a hydrophobic bleach activator and a source of hydrogen peroxide, the bleach activator undergoes perhydrolysis to form a peroxyacid bleaching agent. A by-product of the perhydrolysis reaction between such bleach activators and hydrogen peroxide is a diacylperoxide (DAP) species. It has now further been discovered that the DAP's derived from hydrophobic activators tend to be insoluble, poorly dispersible, oily materials which form a residue which can deposit on the natural rubber machine parts that are exposed to the laundry liquor. The oily DAP residue can form a film on the natural rubber parts and promote free radical and peroxide damage to the rubber, which eventually leads to failure of the part. This is particularly true of rubber parts which have prolonged exposure to the

laundry liquor, such as sump hoses.

By the present invention, it has now been discovered that the class of bleach activators derived from substituted benzoyl caprolactams forms peroxyacids upon perhydrolysis without the production of oily, harmful DAP's. Without intending to be limited by theory, it is believed that the bleach activators employed herein provide good cleaning performance with safety to natural rubber, since they do not expose the natural rubber machine parts or articles to DAP oxidation. Whatever the reason, natural rubber parts and articles remain substantially undamaged by the bleaching systems of the present invention.

By the present invention, it has also now been discovered that the substituted benzoyl caprolactam bleach activators of this invention provide both hydrophilic and hydrophobic cleaning, including dingy soil clean-up and enhanced nucleophilic and body soil removal. Furthermore, the bleaching systems and activators herein are effective at low concentration levels and at temperatures below 60°C which affords less color damage to fabrics than other activators when used in the manner provided by this invention.

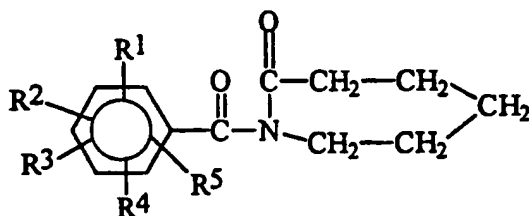
Accordingly, the present invention solves the long-standing need for an effective, color-safe, hydrophobic and hydrophilic bleaching system which does not promote damage to natural rubber parts in washing machines or damage to natural rubber articles.

#### BACKGROUND ART

U.S. Patent 4,545,784, Sanderson, issued October 8, 1985, discloses the adsorption of activators onto sodium perborate monohydrate.

#### SUMMARY OF THE INVENTION

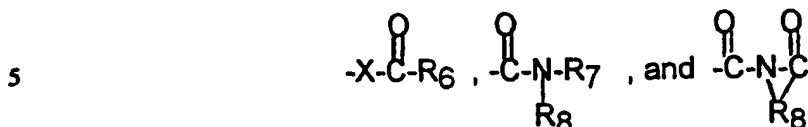
The present invention relates to substituted benzoyl caprolactam bleach activators and their use in bleaching systems and laundry detergents. The substituted benzoyl caprolactams have the formula:



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wherein R<sup>1</sup>, R<sup>2</sup>, R<sup>3</sup>, R<sup>4</sup>, and R<sup>5</sup> contain from 1 to 12 carbon atoms, preferably from

1 to 6 carbon atoms and are members selected from the group consisting of H, halogen, alkyl, alkoxy, alkoxyaryl, alkaryl, alkaryloxy, and members having the structure:

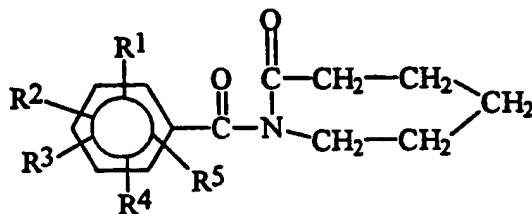


wherein  $\text{R}_6$  is selected from the group consisting of H, alkyl, alkaryl, alkoxy, alkoxyaryl, alkaryloxy, and aminoalkyl; X is O, NH, or  $\text{NR}_7$ , wherein  $\text{R}_7$  is H or a  $\text{C}_1$ - $\text{C}_4$  alkyl group; and  $\text{R}_8$  is an alkyl, cycloalkyl, or aryl group containing from 3 to 11 carbon atoms; provided that at least one R substituent is not H.

In a preferred embodiment,  $\text{R}^1$ ,  $\text{R}^2$ ,  $\text{R}^3$ , and  $\text{R}^4$  are H and  $\text{R}^5$  is selected from the group consisting of methyl, methoxy, ethyl, ethoxy, propyl, propoxy, isopropyl, isopropoxy, butyl, tert-butyl, butoxy, tert-butoxy, pentyl, pentoxy, hexyl, hexoxy, Cl, and  $\text{NO}_2$ . In another preferred embodiment,  $\text{R}^1$ ,  $\text{R}^2$ ,  $\text{R}^3$  are H, and  $\text{R}^4$  and  $\text{R}^5$  are members selected from the group consisting of methyl, methoxy, and Cl.

The invention also relates to bleaching systems and laundry detergents comprising the bleach activators. Said bleaching system comprises:

- a) at least about 0.1%, preferably from about 1% to about 75%, by weight, of a peroxygen bleaching compound capable of yielding hydrogen peroxide in an aqueous solution;
- b) at least about 0.1%, preferably from about 0.1% to about 50%, by weight, of one or more substituted benzoyl caprolactam bleach activators having the formula:



wherein  $\text{R}^1$ ,  $\text{R}^2$ ,  $\text{R}^3$ ,  $\text{R}^4$ , and  $\text{R}^5$  are as defined above.

The peroxygen bleaching compound can be any peroxide source, and is preferably a member selected from the group consisting of sodium perborate monohydrate, sodium perborate tetrahydrate, sodium pyrophosphate peroxyhydrate, urea peroxyhydrate, sodium percarbonate, sodium peroxide and mixtures thereof. Highly preferred peroxygen bleaching compounds are selected from the group consisting of sodium perborate monohydrate, sodium perborate tetrahydrate, sodium percarbonate and mixtures thereof. The most highly preferred peroxygen bleaching

comp und is sodium percarbonate.

The invention also encompasses laundry compositions in granular, paste, liquid, or bar form which comprise the aforesaid bleaching system together with detergent ingredients which are present in the composition at the levels indicated hereinafter.

The substituted benzoyl caprolactam herein can also be used in combination with other bleach activators, such as N-alkyl capro- lactam, unsubstituted benzoyl caprolactam, tetraacetyl ethylene diamine, alkanoxybenzenesulfonate, including nonanoyloxybenzene- sulfonate, benzoxazin-type bleach activators, and peroxyacid agents and activators having amide moieties.

The bleaching method herein is preferably conducted with agitation of the fabrics with an aqueous liquor containing the aforesaid bleaching system at levels from about 50 ppm to about 27,500 ppm. The method can be carried out at any desired washing temperature, even at temperatures below about 60°C, and is readily conducted at temperatures in the range of from about 5°C to about 45°C. The method can be conducted conveniently using a composition which is in bar form, but can also be conducted using granules, flakes, powders, pastes, and the like.

The aqueous laundry liquor typically comprises at least about 300 ppm of conventional detergent ingredients, as well as at least about 25 ppm of the bleaching compound and at least about 25 ppm of a bleach activator. Preferably, the liquor comprises from about 900 ppm to about 20,000 ppm of conventional detergent ingredients, from about 100 ppm to about 25,000 ppm of the-bleaching compound and from about 100 ppm to about 2,500 ppm of the bleach activator. The conventional detergent ingredients and bleaching system will typically be combined into a detergent composition such as a granular laundry detergent or laundry detergent bar.

The conventional detergent ingredients employed in said method and in the compositions herein comprise from about 1% to about 99.8%, preferably from about 5% to about 80%, of a deterative surfactant. Optionally, the detergent ingredients comprise from about 5% to about 80% of a detergent builder. Other optional deterative adjuncts can also be included in such compositions at conventional usage levels.

All percentages, ratios, and proportions herein are by weight, unless otherwise specified. All documents cited are incorporated herein by reference.

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#### DETAILED DESCRIPTION OF THE INVENTION

The bleaching system employed in the present invention provides effective



and efficient surface bleaching of fabrics which thereby removes stains and/or soils from the fabrics. The bleaching system is particularly efficient at cleaning a mixture of soil loads, especially mixtures of hydrophobic and hydrophilic soils. Hydrophobic soils are generally associated with nucleophilic, lipid and protein-based soils and stains, such as body soils, blood, etc., but are also effective on so-called "dingy soils". Dingy soils are those that build up on textiles after numerous cycles of usage and washing, and result in a gray or yellow tint on white fabrics. Hydrophilic soils include food and beverage stains. Further, the bleaching system is safe to natural rubber machine parts and articles.

Substituted benzoyl caprolactams have been found to be unique among the bleach activator compounds, inasmuch as they appear to exhibit both hydrophobic and hydrophilic bleaching activity. This hydrophobic/hydrophilic bleaching capability makes substituted benzoyl caprolactams the activators of choice for the formulator who is seeking broad spectrum bleaching activity, and wishes to use a single caprolactam activator in the bleaching system.

The bleaching mechanism and, in particular, the surface bleaching mechanism are not completely understood. However, it is generally believed that the bleach activator undergoes nucleophilic attack by a perhydroxide anion, which is generated from the hydrogen peroxide evolved by the peroxygen bleaching compound, to form a peroxycarboxylic acid. This reaction is commonly referred to as perhydrolysis. It is also believed, that the bleach activators within this invention can render peroxygen bleaches more efficient even at laundry liquor temperatures wherein bleach activators are not necessary to activate the bleach, i.e., above about 60°C. Therefore, with bleach systems of the invention, less peroxygen bleach is required to achieve the same level of surface bleaching performance as is obtained with the peroxygen bleach alone.

The components of the bleaching system herein comprise the bleach activator and the peroxide source, as described hereinafter.

#### Bleach Activators

Methods of making substituted benzoyl caprolactams are illustrated by the laboratory syntheses presented in Examples I and II.

Examples of preferred substituted benzoyl caprolactams include methylbenzoyl caprolactam, ethylbenzoyl caprolactam, ethoxybenzoyl caprolactam, propylbenzoyl caprolactam, propoxybenzoyl caprolactam, isopropylbenzoyl caprolactam, isopropoxybenzoyl caprolactam, butylbenzoyl caprolactam, butoxybenzoyl caprolactam, tert-butylbenzoyl caprolactam, tert-butoxybenzoyl

caprolactam, pentylbenzoyl caprolactam, pentoxybenzoyl caprolactam, hexylbenzoyl caprolactam, hexoxybenzoyl caprolactam, 2,4,6-tri-chlorobenzoyl caprolactam, pentafluorobenzoyl caprolactam, dichlorobenzoyl caprolactam, dimethoxybenzoyl caprolactam, 4-nitrobenzoyl caprolactam, 3-chlorobenzoyl caprolactam, 4-chlorobenzoyl caprolactam, 2,4-dichlorobenzoyl caprolactam, terephthaloyl dicaprolactam, and mixtures thereof.

The bleaching system comprises at least about 0.1%, preferably from about 0.1% to about 50%, more preferably from about 1% to about 30%, most preferably from about 3% to about 25%, by weight, of one or more substituted benzoyl caprolactam bleach activator.

When the activators are used, optimum surface bleaching performance is obtained when the pH of the aqueous wash liquor is between about 7.0 and about 10.5, preferably from about 7.0 to about 9.5, most preferably from about 7.5 to about 8.5 in order to facilitate the perhydrolysis reaction. Such pH can be obtained with substances commonly known as buffering agents, which are optional components of the bleaching systems herein.

The bleaching and stain removal performance of the organic peroxyacids, obtained from the bleach activators by the perhydrolysis reaction, is typically optimal at the pKa of the peroxyacid. The pKa is defined as the pH at which the concentration of the peroxyacid and the peroxyacid anion are equal. The organic peroxyacids are weaker acids than the corresponding peroxyacids, and typically exhibit pKa's in the range of about 7 to about 8.5. Examples of organic peroxyacids derived from this invention and their pKa's are 4-methoxyperoxybenzoic acid (pKa = 8.1), 4-methylperoxybenzoic acid (pKa = 8.0), 4-chloroperoxybenzoic acid (pKa = 7.7), 3-chloroperoxybenzoic acid (pKa = 7.6), and 4-nitroperoxybenzoic acid (pKa = 7.3). (see Organic Peroxides, Volume I, D. Swern, Editor, Wiley-Interscience, 1970.)

Since the pKa's of the peroxyacids are approximately neutral and the perhydrolysis reaction is fastest at alkaline pH's, it is often desirable to employ, as a portion of the bleaching system formulation, a pH reduction system. A pH reduction system is one that can release acid to the wash, resulting in a decreasing pH over time. The pH reduction system can release acid by either a chemical reaction in situ or by controlled release of acidic components that are physically entrained, for example, by encapsulation or by coating with water soluble materials. When the wash pH is reduced at a controlled rate by incorporation of a pH reduction system, the bleach activator is first allowed to undergo perhydrolysis at an alkaline pH so as

to form the organic peroxyacid. Then, as the pH of the wash is decreased by the pH reduction system, the wash environment approaches a pH in which the bleaching performance of the organic peroxyacid is maximized.

#### The Peroxygen Bleaching Compound

5       The peroxygen bleaching compounds useful herein are those capable of yielding hydrogen peroxide in an aqueous liquor. These compounds are well known in the art and include hydrogen peroxide and the alkali metal peroxides, organic peroxide bleaching compounds such as urea peroxide, and inorganic persalt bleaching compounds, such as the alkali metal perborates, percarbonates, perphosphates, and  
10       the like. Mixtures of two or more such bleaching compounds can also be used, if desired.

Preferred peroxygen bleaching compounds include sodium perborate, commercially available in the form of mono-, tri-, and tetra-hydrate, sodium pyrophosphate peroxyhydrate, urea peroxy- hydrate, sodium peroxide, and sodium  
15       percarbonate. Particularly preferred are sodium perborate tetrahydrate, sodium perborate monohydrate and sodium percarbonate. Sodium percarbonate is especially preferred because it is very stable during storage and yet still dissolves very quickly in the bleaching liquor. It is believed that such rapid dissolution results in the formation of higher levels of percarboxylic acid and, thus, enhanced surface bleaching  
20       performance.

Highly preferred percarbonate can be in uncoated or coated form. The average particle size of uncoated percarbonate ranges from about 400 to about 1200 microns, most preferably from about 400 to about 600 microns. If coated percarbonate is used, the preferred coating materials include mixtures of carbonate  
25       and sulphate, silicate, borosilicate, or fatty carboxylic acids.

The bleaching system comprises at least about 0.1%, preferably from about 1% to about 75%, more preferably from about 3% to about 40%, most preferably from about 3% to about 25%, by weight, of a peroxygen bleaching compound capable of yielding hydrogen peroxide in an aqueous solution.

30       The weight ratio of bleach activator to peroxygen bleaching compound in the bleaching system typically ranges from about 2:1 to 1:5. In preferred embodiments, the ratio ranges from about 1:1 to about 1:3.

The bleach activator/bleaching compound systems herein are useful per se as bleaches. However, such bleaching systems are especially useful in compositions  
35       which can comprise various detergent adjuncts such as surfactants, builders, enzymes, and the like as disclosed hereinafter.

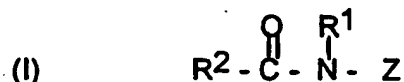
### Deterative Surfactant

The amount of deterative surfactant included in the fully-formulated detergent compositions afforded by the present invention can vary from about 1% to about 99.8%, by weight of the detergent ingredients, depending upon the particular surfactants used and the effects desired. Preferably, the deterative surfactants comprise from about 5% to about 80%, by weight of the detergent ingredients.

The deterative surfactant can be nonionic, anionic, ampholytic, zwitterionic, or cationic. Mixtures of these surfactants can also be used. Preferred detergent compositions comprise anionic deterative surfactants or mixtures of anionic surfactants with other surfactants, especially nonionic surfactants.

Nonlimiting examples of surfactants useful herein include the conventional C<sub>11</sub>-C<sub>18</sub> alkyl benzene sulfonates and primary, secondary, and random alkyl sulfates, the C<sub>10</sub>-C<sub>18</sub> alkyl alkoxy sulfates, the C<sub>10</sub>-C<sub>18</sub> alkyl polyglycosides and their corresponding sulfated polyglycosides, C<sub>12</sub>-C<sub>18</sub> alpha-sulfonated fatty acid esters, C<sub>12</sub>-C<sub>18</sub> alkyl and alkyl phenol alkoxylates (especially ethoxylates and mixed ethoxy/propoxy), C<sub>12</sub>-C<sub>18</sub> betaines and sulfobetaines ("sultaines"), C<sub>10</sub>-C<sub>18</sub> amine oxides, and the like. Other conventional useful surfactants are listed in standard texts.

One particular class of adjunct nonionic surfactants especially useful herein comprises the polyhydroxy fatty acid amides of the formula:



wherein: R<sup>1</sup> is H, C<sub>1</sub>-C<sub>8</sub> hydrocarbyl, 2-hydroxyethyl, 2-hydroxypropyl, or a mixture thereof, preferably C<sub>1</sub>-C<sub>4</sub> alkyl, more preferably C<sub>1</sub> or C<sub>2</sub> alkyl, most preferably C<sub>1</sub> alkyl (i.e., methyl); and R<sup>2</sup> is a C<sub>5</sub>-C<sub>32</sub> hydrocarbyl moiety, preferably straight chain C<sub>7</sub>-C<sub>19</sub> alkyl or alkenyl, more preferably straight chain C<sub>9</sub>-C<sub>17</sub> alkyl or alkenyl, most preferably straight chain C<sub>11</sub>-C<sub>19</sub> alkyl or alkenyl, or mixture thereof; and Z is a polyhydroxyhydrocarbyl moiety having a linear hydrocarbyl chain with at least 2 (in the case of glyceraldehyde) or at least 3 hydroxyls (in the case of other reducing sugars) directly connected to the chain, or an alkoxylated derivative (preferably ethoxylated or propoxylated) thereof. Z preferably will be derived from a reducing sugar in a reductive amination reaction; more preferably Z is a glycityl moiety. Suitable reducing sugars include glucose, fructose, maltose, lactose, galactose, mannose, and xyl se, as well as glyceraldehyde. As raw materials, high dextrose corn syrup, high fructose corn syrup, and high maltose corn syrup can be

utilized as well as the individual sugars listed above. These corn syrups may yield a mix of sugar components for Z. It should be understood that it is by no means intended to exclude other suitable raw materials. Z preferably will be selected from the group consisting of  $-\text{CH}_2-(\text{CHOH})_n-\text{CH}_2\text{OH}$ ,  $-\text{CH}(\text{CH}_2\text{OH})-(\text{CHOH})_{n-1}-\text{CH}_2\text{OH}$ ,  $-\text{CH}_2-(\text{CHOH})_2(\text{CHOR}')-(\text{CHOH})-\text{CH}_2\text{OH}$ , where n is an integer from 1 to 5, inclusive, and R' is H or a cyclic mono- or poly- saccharide, and alkoxyated derivatives thereof. Most preferred are glycityls wherein n is 4, particularly  $-\text{CH}_2-(\text{CHOH})_4-\text{CH}_2\text{OH}$ .

In Formula (I),  $\text{R}^1$  can be, for example, N-methyl, N-ethyl, N-propyl, N-isopropyl, N-butyl, N-isobutyl, N-2-hydroxy ethyl, or N-2-hydroxy propyl. For highest sudsing,  $\text{R}^1$  is preferably methyl or hydroxyalkyl. If lower sudsing is desired,  $\text{R}^1$  is preferably  $\text{C}_2$ - $\text{C}_8$  alkyl, especially n-propyl, iso-propyl, n-butyl, iso-butyl, pentyl, hexyl and 2-ethyl hexyl.

$\text{R}_2-\text{CO}-\text{N}<$  can be, for example, cocamide, stearamide, oleamide, lauramide, myristamide, capricamide, palmitamide, tallowamide, etc.

#### Detergent Builders

Optional detergent ingredients employed in the present invention contain inorganic and/or organic detergent builders to assist in mineral hardness control. If used, these builders comprise from about 5% to about 80% by weight of the detergent compositions.

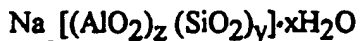
Inorganic detergent builders include, but are not limited to, the alkali metal, ammonium and alkanolammonium salts of polyphosphates (exemplified by the tripolyphosphates, pyrophosphates, and glassy polymeric meta-phosphates), phosphonates, phytic acid, silicates, carbonates (including bicarbonates and sesquicarbonates), sulphates, and aluminosilicates. However, non-phosphate builders are required in some locales.

Examples of silicate builders are the alkali metal silicates, particularly those having a  $\text{SiO}_2:\text{Na}_2\text{O}$  ratio in the range 1.6:1 to 3.2:1 and layered silicates, such as the layered sodium silicates described in U.S. Patent 4,664,839, issued May 12, 1987 to H. P. Rieck, available from Hoechst under the trademark "SKS"; SKS-6 is an especially preferred layered silicate builder.

Carbonate builders, especially a finely ground calcium carbonate with surface area greater than  $10 \text{ m}^2/\text{g}$ , are preferred builders that can be used in granular compositions. The density of such alkali metal carbonate built detergents can be in the range of 450-850 g/l with the moisture content preferably below 4%. Examples of carbonate builders are the alkaline earth and alkali metal carbonates as disclosed in

German Patent Application No. 2,321,001 published on November 15, 1973.

Aluminosilicate builders are especially useful in the present invention. Preferred aluminosilicates are zeolite builders which have the formula:



5 wherein z and y are integers of at least 6, the molar ratio of z to y is in the range from 1.0 to about 0.5, and x is an integer from about 15 to about 264.

Useful aluminosilicate ion exchange materials are commercially available. These aluminosilicates can be crystalline or amorphous in structure and can be naturally-occurring aluminosilicates or synthetically derived. A method for  
10 producing aluminosilicate ion exchange materials is disclosed in U.S. Patent 3,985,669, Krummel, et al, issued October 12, 1976. Preferred synthetic crystalline aluminosilicate ion exchange materials useful herein are available under the designations Zeolite A, Zeolite P (B), and Zeolite X. Preferably, the aluminosilicate has a particle size of about 0.1-10 microns in diameter.

15 Organic detergent builders suitable for the purposes of the present invention include, but are not restricted to, a wide variety of polycarboxylate compounds, such as ether polycarboxylates, including oxydisuccinate, as disclosed in Berg, U.S. Patent 3,128,287, issued April 7, 1964, and Lamberti et al, U.S. Patent 3,635,830, issued January 18, 1972. See also "TMS/TDS" builders of U.S. Patent 4,663,071, issued to  
20 Bush et al, on May 5, 1987.

Other useful detergent builders include the ether hydroxypolycarboxylates, copolymers of maleic anhydride with ethylene or vinyl methyl ether, 1, 3, 5-trihydroxy benzene-2, 4, 6-trisulphonic acid, and carboxymethyloxysuccinic acid, the various alkali metal, ammonium and substituted ammonium salts of polyacetic acids  
25 such as ethylenediamine tetraacetic acid and nitrilotriacetic acid, as well as polycarboxylates such as mellitic acid, succinic acid, oxydisuccinic acid, polymaleic acid, benzene 1,3,5-tricarboxylic acid, carboxymethyloxysuccinic acid, and soluble salts thereof.

Citrate builders, e.g., citric acid and soluble salts thereof (particularly sodium  
30 salt), are preferred polycarboxylate builders that can also be used in granular compositions, especially in combination with zeolite and/or layered silicate builders.

Also suitable in the detergent compositions of the present invention are the 3,3-dicarboxy-4-oxa-1,6-hexanedioates and the related compounds disclosed in U.S. Patent 4,566,984, Bush, issued January 28, 1986.

35 In situations where phosphorus-based builders can be used, and especially in the formulation of bars used for hand-laundering operations, the various alkali metal

phosphates such as the well-known sodium tripolyphosphates, sodium pyrophosphate and sodium orthophosphate can be used. Phosphonate builders such as ethane-1-hydroxy-1,1-diphosphonate and other known phosphonates (see, for example, U.S. Patents 3,159,581; 3,213,030; 3,422,021; 3,400,148 and 3,422,137) can also be used.

#### Optional Deterative Adjuncts

As a preferred embodiment, the conventional detergent ingredients employed herein can be selected from typical detergent composition components such as deterative surfactants and detergent builders. Optionally, the detergent ingredients can include one or more other deterative adjuncts or other materials for assisting or enhancing cleaning performance, treatment of the substrate to be cleaned, or to modify the aesthetics of the detergent composition. Usual deterative adjuncts of detergent compositions include the ingredients set forth in U.S. Pat. No. 3,936,537, Baskerville et al. Adjuncts which can also be included in detergent compositions employed in the present invention, in their conventional art-established levels for use (generally from 0% to about 20% of the detergent ingredients, preferably from about 0.5% to about 10%), include enzymes, especially proteases, lipases and cellulases, color speckles, suds boosters, suds suppressors, antitarnish and/or anticorrosion agents, soil-suspending agents, soil release agents, dyes, fillers, optical brighteners, germicides, alkalinity sources, hydrotropes, antioxidants, enzyme stabilizing agents, perfumes, solvents, solubilizing agents, clay soil removal/anti-redeposition agents, polymeric dispersing agents, processing aids, fabric softening components static control agents, etc.

Bleach systems optionally, but preferably, will also comprise a chelant which not only enhances bleach stability by scavenging heavy metal ions which tend to decompose bleaches, but also assists in the removal of polyphenolic stains such as tea stains, and the like. Various chelants, including the aminophosphonates, available as DEQUEST from Monsanto, the nitrilotriacetates, the hydroxyethyl-ethylenediamine triacetates, and the like, are known for such use. Preferred biodegradable, non-phosphorus chelants include ethylenediamine disuccinate ("EDDS"; see U.S. Patent 4,704,233, Hartman and Perkins), ethylenediamine-N,N'-diglutamate (EDDG) and 2-hydroxypropylenediamine-N,N'-disuccinate (HPDDS) compounds. Such chelants can be used in their alkali or alkaline earth metal salts, typically at levels from about 0.1% to about 10% of the present compositions.

Optionally, the detergent compositions employed herein can comprise, in addition to the bleaching system of the present invention, one or more ther

conventional bleaching agents, activators, or stabilizers. In general, the formulator will ensure that the bleach compounds used are compatible with the detergent formulation. Conventional tests, such as tests of bleach activity on storage in the presence of the separate or fully-formulated ingredients, can be used for this purpose.

5        Specific examples of optional bleach activators for incorporation in this invention include tetraacetyl ethylene diamine (TAED), alkanoyloxybenzenesulfonates, including nonanoyloxybenzene-sulfonate and benzoyloxybenzenesulfonate, the benzoxazin-type bleaching activators disclosed in U.S. Patent 4,966,723, Hodge et al, issued Oct. 30, 1990, and the peroxyacid agents  
10       and activators having amide moieties disclosed in U.S. Patent 4,634,551, Burns et al, issued Jan. 6, 1987. Such bleaching compounds and agents can be optionally included in detergent compositions in their conventional art-established levels of use, generally from 0% to about 15%, by weight of detergent composition.

      Bleaching activators of the invention are especially useful in conventional  
15       laundry detergent compositions such as those typically found in granular detergents or laundry bars. U.S. Patent 3,178,370, Okenfuss, issued April 13, 1965, describes laundry detergent bars and processes for making them. Philippine Patent 13,778, Anderson, issued Sept. 23, 1980, describes synthetic detergent laundry bars. Methods for making laundry detergent bars by various extrusion methods are well  
20       known in the art.

      The following examples are given to further illustrate the present invention, but are not intended to be limiting thereof.

#### EXAMPLE I

      Synthesis of 4-ethoxybenzoyl caprolactam - To a 500 ml flask equipped with  
25       a reflux condenser and overhead stirrer is charged 0.18 moles of 4-ethoxybenzoic acid, 200 ml of chloroform, and 0.54 moles of thionyl chloride. The resulting solution is heated to reflux, refluxed with stirring for 3 hrs, and then stirred at room temperature for 18 hrs. The chloroform is removed by rotary evaporation to yield the acid chloride (0.18 moles). A one liter 3-neck flask is fitted with an addition  
30       funnel, reflux condenser, and mechanical stirrer. The flask is charged with 0.18 moles of caprolactam, triethyl amine (0.20 moles) and 450 ml of p-dioxane. The acid chloride is added as a solution in 50 ml p-dioxane over a period of 15 min. The resulting mixture is refluxed for 3.5 hrs. After cooling to room temperature, the precipitated solid is filtered and the dioxane removed by rotary evaporation. The  
35       residue is recrystallized from chloroform to yield 0.13 moles of 4-ethoxybenzoyl caprolactam, which NMR analysis shows to be 93% pure. The 4-ethoxybenzoyl



caprolactam has a melting point of 108-111°C. <sup>1</sup>H NMR reveals 1.4 ppm (t, 3H); 1.8 ppm (m, 6H); 2.7 ppm (m, 2H); 3.9 ppm (m, 2H); 4 ppm (q, 2H), 6.9 ppm (d, 2H); 7.6 ppm (d, 2H). <sup>13</sup>C NMR provides 15 ppm (s); 24 ppm (s); 29 ppm (d); 39 ppm (s); 46 ppm (s); 64 ppm (s); 114 ppm (s); 128 ppm (s); 131 ppm (s); 162 ppm (s); 174 ppm (s); 178 ppm (s). IR (cm<sup>-1</sup>) at 2930, 1667, 1604, 1254.

#### EXAMPLE II

Synthesis of 4-nitrobenzoyl caprolactam - To a 1 liter flask equipped with drying tybe, condenser, and overhead stirrer is charged 0.3 moles of 4-nitrobenzoyl chloride, 0.3 moles of caprolactam, 0.33 moles of triethylamine and 300 ml of toluene. The resultant mixture is heated to reflux, refluxed with stirring for 6 hours, cooled and filtered. The filtrate is washed with 3x25 ml of water and dried over anhydrous magnesium sulphate. To the filtrate is added 500 ml of hexane, and after stirring for 20 minutes, the resultant precipitate is collected via vacuum filtration to yield 0.15 moles of 4-nitrobenzoyl caprolactam which NMR analysis shows to be 95% pure. The 4-nitrobenzoyl caprolactam has a melting point of 102°C. <sup>1</sup>H NMR reveals 1.8 ppm (Broad s, 6H); 2.7 ppm (m, 2H); 4 ppm (m, 2H); 7.6 ppm (d, 2H); 8.2 ppm (d, 2H). <sup>13</sup>C NMR provides 24 ppm (s); 29 ppm (d); 39 ppm (s); 45 ppm (s); 123 ppm (s); 128 ppm (s); 143 ppm (s); 148 ppm (s); 172 ppm (s); 177 ppm (s). IR (cm<sup>-1</sup>) at 2934, 1681, 1602, 1522, 1348.

#### EXAMPLE III

Synthesis of 3-chlorobenzoyl caprolactam - To a 1 liter flask equipped with argon sweep, condenser and overhead stirrer is charged 0.25 moles of caprolactam, 0.275 moles of triethylamine, and 200 ml of toluene. The resultant mixture is heated to reflux. A solution of 0.25 moles of 3-chlororbenzoyl chloride in 50 ml of toluene is added over 30 minutes, and the mixture refluxed with stirring for 6 hours, cooled and filtered. The filtrate is washed with 3x50 ml of water and dried over anhydrous magnesium sulphate. To the filtrate is added 500 ml of hexane, and the resultant solution placed in a freezer for 6 hours. After which time, the resultant precipitate is collected via vacuum filtration to yield 0.14 moles of 3-chlorobenzoyl caprolactam which NMR analysis shows to be 98% pure. The 3-chlorobenzoyl caprolactam has a melting point of approximately 69-73°C. <sup>1</sup>H NMR reveals 1.8 ppm (Broad s, 6H); 2.7 ppm (m, 2H); 4 ppm (m, 2H); 7.4 ppm (m, 4H). <sup>13</sup>C NMR provides 24 ppm (s); 29 ppm (d); 39 ppm (s); 45 ppm (s); 126 ppm (s); 128 ppm (s); 129 ppm (s); 131 ppm (s); 134 ppm (s); 138 ppm (s); 173 ppm (s), and 178 ppm (s). IR (cm<sup>-1</sup>) at 2932, 1681, 1262.

#### EXAMPLE IV

Synthesis of 4-butoxybenzoyl caprolactam - To a 500 ml flask equipped with drying tube, condenser and overhead stirrer is charged 0.13 moles of 4-butoxybenzoic acid, 0.39 moles of thionyl chloride, and 150 ml of diethyl ether. The resultant mixture is heated to reflux, and the mixture is refluxed with stirring for 3 hours and cooled. The diethyl ether and excess thionyl chloride is removed by rotary evaporation to yield the acid chloride (0.13 moles).

To a 1 liter flask equipped with drying tube, condenser and overhead stirrer is charged 0.13 moles of caprolactam, 0.16 moles of triethylamine and 150 ml of dioxane. The resultant solution is heated to reflux, and a solution of 0.13 moles of 4-butoxybenzoyl chloride in 50 ml of dioxane is added over 15 minutes. The mixture is refluxed with stirring for 3 hours followed by stirring at room temperature for a further 18 hours. The mixture is filtered, and the solvent removed by rotary evaporation leaving a brown oil which is recrystallized from 25 ml of carbon tetrachloride to yield 0.73 moles of 4-butoxybenzoyl caprolactam which NMR shows to be 90% pure. The 4-butoxybenzoyl caprolactam has a melting point of approximately 87-92°C. <sup>1</sup>H NMR reveals 0.9 ppm (t, 3H); 1.2-1.8 ppm (m, 12H); 2.7 ppm (m, 2H); 3.8 ppm (m, 2H); 4 ppm (t, 2H); 6.9 ppm (d, 2H); 7.5 ppm (d, 2H). <sup>13</sup>C NMR provides 14 ppm (s); 20 ppm (s); 24 ppm (s); 29 ppm (d); 31 ppm (s); 39 ppm (s); 46 ppm (s); 68 ppm (s); 114 ppm (s); 128 ppm (s); 131 ppm (s); 162 ppm (s); 174 ppm (s); 178 ppm (s). IR (cm<sup>-1</sup>) at 2933, 1677, 1604, 1254.

#### EXAMPLE V

A granular detergent composition is prepared comprising the following ingredients.

	<u>Component</u>	<u>Weight %</u>
25	C <sub>12</sub> linear alkyl benzene sulfonate	22
	Phosphate (as sodium tripolyphosphate)	20
	Sodium carbonate	10
	Sodium silicate	3
	Sodium percarbonate*	20
30	Ethylenediamine disuccinate chelant (EDDS)	0.4
	Sodium sulfate	5.5
	4-ethoxybenzoyl caprolactam	10
	Minors, filler** and water	Balance to 100%

\* Average particle size of 400 to 1200 microns.

35 \*Can be selected from convenient materials such as CaCO<sub>3</sub>, talc, clay, silicates, and the like.

Aqueous crutcher mixes of heat and alkali stable components of the detergent compositions are prepared and spray-dried. The other ingredients are admixed so that the detergent composition contains the ingredients tabulated at the levels shown.

The detergent granules with bleaching system are added together with a 6 lb.  
5 (2.7 kg) load of fabrics to a Sears KENMORE washing machine. Actual weights of detergent and ester compositions are taken to provide a 1000 ppm concentration of the detergent composition in the 17 gallon (65 l) water-fill machine. The water used has 7 grains/gallon hardness and a pH of 7 to 7.5 prior to (about 9 to about 10.5 after) addition of the detergent composition.

10 The fabrics are laundered at 35°C (95°F) for a full cycle (12 min.) and rinsed at 21°C (70°F).

At the end of the last rinse cycle, the test fabrics are dried in a dryer. Tristimulus meter readings (L,a,b) are then determined for each test fabric. Whiteness performance in terms of Hunter Whiteness Values (W) is then calculated  
15 according to the following equation:

$$W = (7L^2 - 40Lb)/700$$

The higher the value for W, the better the whiteness performance. In the above test, fabrics exposed to the bleaching system display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the  
20 bleaching system of the invention.

#### EXAMPLE VI

A granular detergent is prepared by a procedure identical to that of Example V, with the exception that 20% ethylbenzoyl caprolactam is substituted for the 4-ethoxybenzoyl caprolactam bleach activator. The laundering method of Example V  
25 is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE VII

A granular detergent is prepared by a procedure identical to that of Example  
30 V, with the exceptions that 10% propylbenzoyl caprolactam is substituted for the 4-ethoxybenzoyl caprolactam bleach activator. The laundering method of Example V is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE VIII

A granular detergent is prepared by a procedure identical to that of Example

V, with the exceptions that 5% propoxybenzoyl caprolactam is substituted for the 4-ethoxybenzoyl caprolactam bleach activator and the amount of sodium percarbonate is 10%. The laundering method of Example V is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE IX

A granular detergent is prepared by a procedure identical to that of Example V, with the exceptions that 20% butoxybenzoyl caprolactam is substituted for the 4-ethoxybenzoyl caprolactam bleach activator and the amount of sodium percarbonate is 20%. The laundering method of Example V is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE X

A granular detergent is prepared by a procedure identical to that of Example V, with the single exception that 15% of a 1:1 mixture of 4-butylbenzoyl caprolactam and 3-nitrobenzoyl caprolactam is substituted for the 4-ethoxybenzoyl caprolactam bleach activator. The laundering method of Example V is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE XI

A granular detergent composition is prepared comprising the following ingredients.

	<u>Component</u>	<u>Weight %</u>
	Anionic alkyl sulfate	7
25	Nonionic surfactant	5
	Zeolite (0.1-10 micron)	10
	Trisodium citrate	2
	SKS-6 silicate builder	10
	Acrylate maleate polymer	4
30	2,4-dimethylbenzoyl caprolactam	10
	Sodium percarbonate	25
	Sodium carbonate	5
	Ethylenediamine disuccinate chelant (EDDS)	0.4
	Suds suppressor	2
35	Enzymes*	1.5
	Soil release agent	0.2

Minors, filler\*\* and water                      Balance to 100%

\*1:1:1 mixture of protease, lipase, and cellulase.

\*\*Can be selected from convenient materials such as CaCO<sub>3</sub>, talc, clay, silicates, and the like.

5            Aqueous crutcher mixes of heat and alkali stable components of the detergent compositions are prepared and spray-dried and the other ingredients are admixed so that they contain the ingredients tabulated at the levels shown.

          The detergent granules with bleaching system are added together with a 2.7 kg load of fabrics to an automatic washing machine. Actual weights of detergent and  
10       ester compositions are taken to provide a 5000 ppm concentration of the detergent composition in the 17 liter (4.5 gallon) water-fill machine. The water used has 10 grains/ gallon hardness and a pH of 7 to 7.5 prior to (about 9 to about 10.5 after) addition of the detergent composition.

          The fabrics are laundered at 40°C (104°F) for a full cycle (40 min.) and rinsed  
15       at 21°C (70°F).

          At the end of the last rinse cycle, the test fabrics are dried in a dryer. Tristimulus meter readings (L,a,b) are then determined for each test fabric. Whiteness performance in terms of Hunter Whiteness Values (W) is then calculated according to the following equation:

20                      
$$W = (7L^2 - 40Lb)/700$$

          The higher the value for W, the better the whiteness performance. In the above test, fabrics exposed to the bleaching system display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

25                      EXAMPLE XII

          A granular detergent is prepared by a procedure identical to that of Example XI, with the exception that 10% ethylbenzoyl caprolactam is substituted for the 2,4-dimethylbenzoyl caprolactam bleach activator. The laundering method of Example XI is repeated. In the test, all fabrics display significantly improved whiteness after  
30       laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

EXAMPLE XIII

          A granular detergent is prepared by a procedure identical to that of Example XI, with the exceptions that 10% propylbenzoyl caprolactam is substituted for the  
35       2,4-dimethylbenzoyl caprolactam bleach activator. The laundering method of Example XI is repeated. In the test, all fabrics display significantly improved

whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE XIV

5 A granular detergent is prepared by a procedure identical to that of Example XI, with the exceptions that 15% propoxybenzoyl caprolactam is substituted for the 2,4-dimethylbenzoyl caprolactam bleach activator and the amount of sodium percarbonate is 30%. The laundering method of Example XI is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

10

#### EXAMPLE XV

A granular detergent is prepared by a procedure identical to that of Example XI, with the exceptions that 20% butoxybenzoyl caprolactam is substituted for the 2,4-dimethylbenzoyl caprolactam bleach activator and the amount of sodium percarbonate is 20%. The laundering method of Example XI is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

15

#### EXAMPLE XVI

A granular detergent is prepared by a procedure identical to that of Example XI, with the single exception that 15% of a 1:1 mixture of nitrobenzoyl caprolactam and nonanoyloxybenzenesulfonate is substituted for the 2,4-dimethylbenzoyl caprolactam bleach activator. The laundering method of Example XI is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

20

#### EXAMPLE XVII

A laundry bar suitable for hand-washing soiled fabrics is prepared comprising the following ingredients.

25

	<u>Component</u>	<u>Weight %</u>
	C <sub>12</sub> linear alkyl benzene sulfonate	30
30	Phosphate (as sodium tripolyphosphate)	7
	Sodium carbonate	15
	Sodium pyrophosphate	7
	Coconut monoethanolamide	2
	Zeolite A (0.1-10 microns)	5
35	Carboxymethylcellulose	0.2
	Polyacrylate (m.w. 1400)	0.2

	3-chlorobenzoyl caprolactam	6.5
	Sodium percarbonate	15
	Brightener, perfume	0.2
	Protease	0.3
5	CaSO <sub>4</sub>	1
	MgSO <sub>4</sub>	1
	Water and Filler*	Balance to 100%

\*Can be selected from convenient materials such as CaCO<sub>3</sub>, talc, clay, silicates, and the like.

10 The detergent laundry bars are processed in conventional soap or detergent bar making equipment as commonly used in the art. Testing is conducted following the methods used in Example VI. In the test, fabrics exposed to the bleaching system display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### 15 EXAMPLE XVIII

A laundry bar is prepared by a procedure identical to that of Example XVII, with the two exceptions that 15% of a 1:1:1 mixture of nitrobenzoyl caprolactam, 3-chlorobenzoyl caprolactam, and nonanoyloxybenzenesulfonate is substituted for the 3-chlorobenzoyl caprolactam bleach activator, and the level of sodium percarbonate is increased to 20%. The laundering method of Example XVII is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE XIX

25 A laundry bar is prepared by a procedure identical to that of Example XVII, with the single exception that 15% of a 1:1 mixture of 3-methoxybenzoyl caprolactam and tetraacetyl ethylene diamine is substituted for the 3-chlorobenzoyl caprolactam bleach activator. The laundering method of Example XVII is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE XX

35 A laundry bar is prepared by a procedure identical to that of Example XVII, with the single exception that 10% of a 1:1 mixture of 3,5,5-trimethylhexanoyloxybenzenesulfonate and 3-propoxybenzoyl caprolactam is substituted for the 3-chlorobenzoyl caprolactam bleach activator. The laundering method of Example XVII is repeated. In the test, all fabrics display significantly

improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE XXI

A laundry bar is prepared by a procedure identical to that of Example XVII, with the single exception that 10% of a 1:1 mixture of 4-butoxybenzoyl caprolactam and a benzoxazin-type bleach activator, as disclosed in U.S. Pat. 4,966,723, is substituted for the 3-chlorobenzoyl caprolactam bleach activator. The laundering method of Example XVII is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE XXII

A bleaching system is prepared comprising the following ingredients.

<u>Component</u>	<u>Weight %</u>
4-butylbenzoyl caprolactam	15
Tetraacetyl ethylene diamine	15
Sodium percarbonate	45
Chelant (ethylenediamine disuccinate, EDDS)	10
Filler* and water	Balance to 100%

\*Can be selected from convenient materials such as  $\text{CaCO}_3$ , talc, clay, silicates, and the like.

Testing is conducted following the methods used in Example VI with the single exception that the an equivalent amount of the above bleaching system is substituted for the detergent composition used in Example VI. In the test, fabrics exposed to the bleaching system display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

While the compositions and processes of the present invention are useful in conventional laundering operations, it is to be understood that they are also useful in any cleaning system which involves low water: fabric ratios. One such system is disclosed in U.S. Patent 4,489,455, Spindel, issued Dec. 25, 1984, which involves a washing machine apparatus which contacts fabrics with wash water containing detergent ingredients using a low water: fabric ratio rather than the conventional method of immersing fabrics in an aqueous bath. The compositions herein provide excellent bleaching performance in such mechanical systems. Typically, the ratio of water: fabric ranges from about 0.5:1 to about 6:1 (liters of water: kg of fabric).

#### EXAMPLE XXIII



Using the machine and operating conditions disclosed in U.S. Patent 4,489,455, cited above, 25 grams of a composition according to Example VI herein are used to launder fabrics with concurrent bleaching. If desired, sudsing of the composition can be minimized by incorporating therein from 0.2% to 2% by weight of a fatty acid, secondary alcohol, or silicone suds controlling ingredient. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

Contrary to the teachings of U.S. Pat. 4,545,784, cited above, caprolactam bleach activators are preferably not absorbed onto the peroxygen bleaching compound. To do so in the presence of other organic detergent ingredients could cause safety problems. It has now been discovered that the substituted benzoyl caprolactam bleach activators of this invention can be dry-mixed with peroxygen bleaching compounds, especially perborate, and thereby avoid potential safety problems.

15

**EXAMPLE XXIV**

A laundry bar suitable for hand-washing soiled fabrics is prepared comprising the following ingredients.

	<u>Component</u>	<u>Weight %</u>
	Linear alkyl benzene sulfonate	30
20	Phosphate (as sodium tripolyphosphate)	7
	Sodium carbonate	20
	Sodium pyrophosphate	7
	Coconut monoethanolamide	2
	Zeolite A (0.1-10 microns)	5
25	Carboxymethylcellulose	0.2
	Polyacrylate (m.w. 1400)	0.2
	2-methoxybenzoyl caprolactam	5
	Sodium perborate tetrahydrate	10
	Brightener, perfume	0.2
30	Protease	0.3
	CaSO <sub>4</sub>	1
	MgSO <sub>4</sub>	1
	Water	4
	Filler*	Balance to 100%
35	Can be selected from convenient materials such as CaCO <sub>3</sub> , talc, clay, silicates, and the like.	

The detergent laundry bars are processed in conventional soap or detergent bar making equipment as commonly used in the art with the bleaching activator dry-mixed with the perborate bleaching compound and not affixed to the surface of the perborate. Testing is conducted following the methods used in Example VI. In the  
5 test, fabrics exposed to the bleaching system display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE XXV

A laundry bar is prepared by a procedure identical to that of Example XXIV,  
10 with the single exception that an equivalent amount of 4-propoxybenzoyl caprolactam is substituted for the 2-methoxybenzoyl caprolactam bleach activator. The laundering method of Example XXIV is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE XXVI

A laundry bar is prepared by a procedure identical to that of Example XXIV, with the exception that 10% of a 1:1 mixture of 4-butoxybenzoyl caprolactam and a bleach activator as disclosed in U.S. Pat. 4,634,551 is substituted for the 2-methoxybenzoyl caprolactam bleach activator. The laundering method of Example  
20 XXIV is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE XXVII

A laundry bar is prepared by a procedure identical to that of Example XXIV,  
25 with the single exception that 10% of a 1:1 mixture of 3-chlorobenzoyl caprolactam and a benzoxazin-type bleach activator, as disclosed in U.S. Pat. 4,966,723, is substituted for the 2-methoxybenzoyl caprolactam bleach activator. The laundering method of Example XXIV is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been  
30 exposed to the bleaching system of the invention.

#### EXAMPLE XXVIII

A granular detergent composition is prepared comprising the following ingredients.

	<u>Component</u>	<u>Weight %</u>
35	Linear alkyl benzene sulfonate	20
	Phosphate (as sodium tripolyphosphate)	20

	Sodium carbonate	10
	Sodium silicate	3
	Sodium perborate tetrahydrate	20
	Ethylenediamine disuccinate chelant (EDDS)	0.4
5	Sodium sulfate	5.5
	Propoxybenzoyl caprolactam	5
	Nonanoyloxybenzenesulfonate	5
	Minors, filler** and water	Balance to 100%

10      \*\*Can be selected from convenient materials such as  $\text{CaCO}_3$ , talc, clay, silicates, and the like.

Aqueous crutcher mixes of heat and alkali stable components of the detergent compositions are prepared and spray-dried and the other ingredients are dry-mixed so that they contain the ingredients tabulated at the levels shown.

15      Testing is conducted following the methods used in Example VI. In the test, fabrics exposed to the bleaching system display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

#### EXAMPLE XXIX

20      A granular detergent is prepared by a procedure identical to that of Example XXVIII, with the exception that an equivalent amount of 2,4,6-trichlorobenzoyl caprolactam is substituted for the propoxybenzoyl caprolactam bleach activator. The laundering method of Example XXVIII is repeated. In the test, all fabrics display significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

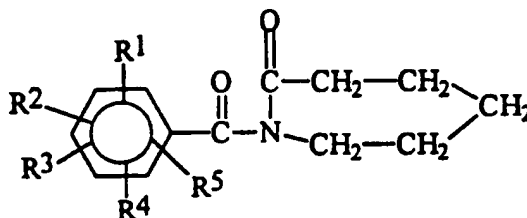
#### 25      EXAMPLE XXX

A granular detergent is prepared by a procedure identical to that of Example XXVIII, with the single exception that an equivalent amount of pentafluorobenzoyl caprolactam is substituted for the propoxybenzoyl caprolactam bleach activator. The laundering method of Example XXVIII is repeated. In the test, all fabrics display  
30      significantly improved whiteness after laundering compared with fabrics which have not been exposed to the bleaching system of the invention.

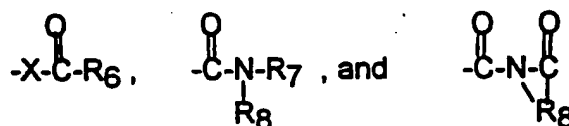
WHAT IS CLAIMED IS:

What is claimed is:

1. A substituted benzoyl caprolactam bleach activator having the formula:



wherein  $R^1$ ,  $R^2$ ,  $R^3$ ,  $R^4$ , and  $R^5$  are members selected from the group consisting of H, halogen, alkyl, alkoxy, alkoxyaryl, alkaryl, alkaryloxy, and substituents having the structure:



wherein  $R_6$  is selected from the group consisting of H, alkyl, alkaryl, alkoxy, alkoxyaryl, alkaryloxy, and aminoalkyl; X is O, NH, or  $NR_7$ , wherein  $R_7$  is H or a  $C_1$ - $C_4$  alkyl group; and  $R_8$  is an alkyl, cycloalkyl, or aryl group containing from 3 to 11 carbon atoms; provided that at least one R substituent is not H.

2. A bleach activator according to Claim 1 wherein  $R^1$ ,  $R^2$ ,  $R^3$ , and  $R^4$  are H and  $R^5$  is selected from the group consisting of methyl, methoxy, ethyl, ethoxy, propyl, propoxy, isopropyl, isopropoxy, butyl, butoxy,  $C_1$ ,  $NO_3$  and mixtures thereof.
3. A bleach activator according to Claim 1 wherein  $R^1$ ,  $R^2$ , and  $R^3$  are each H and  $R^4$  and  $R^5$  are members selected from the group consisting of methyl, methoxy, and Cl.
4. A laundry bleaching system comprising:
  - i) at least 0.1% by weight of a peroxygen bleaching compound; and
  - ii) at least 0.1% by weight of a substituted benzoyl caprolactam bleach activator according to Claim 1.
5. A laundry detergent composition comprising:

- i) at least 0.1% by weight of a peroxygen bleaching compound, preferably percarbonate or perborate;
  - ii) at least 0.1% by weight of a substituted benzoyl caprolactam bleach activator according to Claim 1;
  - iii) from 5% to 80% by weight of a deterative surfactant; and, optionally,
  - iv) from 5% to 80% of a detergent builder.
6. A composition according to Claim 5 further comprising a second bleach activator selected from the group consisting of tetraacetyl ethylene diamine, benzoyl caprolactam, nonanoyloxybenzenesulfonate, benzoxazin-type activators, peroxyacid activators having amide moieties, and mixtures thereof.
7. A composition according to Claim 6 wherein  $R^1$ ,  $R^2$ ,  $R^3$  and  $R^4$  are H;  $R^5$  is selected from the group consisting of ethyl, ethoxy, propyl, propoxy, isopropyl, isopropoxy, butyl, butoxy, tert-butyl, tert-butoxy, pentyl, pentoxy, hexyl, hexoxy, and mixtures thereof; and the second bleach activator is tetraacetyl ethylene diamine or benzoyl caprolactam.
8. A composition according to Claim 6 wherein the substituted benzoyl caprolactam is selected from the group consisting of 4-chlorobenzoyl caprolactam, 4-nitrobenzoyl caprolactam, 2,4-dichlorobenzoyl caprolactam, 2,4,6-trichlorobenzoyl caprolactam, pentafluoro-benzoyl caprolactam, and mixtures thereof; and the second bleach activator is nonanoyloxybenzenesulfonate.
9. A composition according to Claim 6 wherein the substituted benzoyl caprolactam is selected from the group consisting of 4-chlorobenzoyl caprolactam, 4-nitrobenzoyl caprolactam, 2,4-dichlorobenzoyl caprolactam, 2,4,6-trichlorobenzoyl caprolactam, pentafluoro-benzoyl caprolactam, and mixtures thereof; and the second bleach activator is a benzoxazin-type activator.
10. A composition according to Claim 5 in granular form wherein the substituted benzoyl caprolactam bleach activator is dry-mixed with the peroxygen bleaching compound.

11. A composition according to Claim 5 in bar form wherein the peroxygen bleaching compound is perborate or percarbonate.
12. A composition according to Claim 5 further comprising a pH reduction system which releases acid.
13. A composition according to Claim 12 wherein said acid is formed in situ by chemical reaction.
14. A composition according to Claim 12 wherein said acid is encapsulated.
15. A method for cleaning fabrics, said method comprising contacting said fabrics in an aqueous liquor comprising a bleaching system which comprises:
  - a) at least 0.1% by weight of a peroxygen bleaching compound capable of yielding hydrogen peroxide in an aqueous solution wherein the peroxygen bleaching compound is preferably selected from the group consisting of sodium perborate monohydrate, sodium perborate tetrahydrate, sodium pyrophosphate peroxyhydrate, urea peroxyhydrate, sodium percarbonate, sodium peroxide and mixtures thereof; and
  - b) at least 0.1% by weight of one or more substituted benzoyl caprolactam bleach activators according to Claim 1.
16. A method according to Claim 15 wherein said bleaching system further comprises a second bleach activator selected from the group consisting of alkanoyloxybenzenesulfonate, tetraacetyl ethylene diamine, benzoyl caprolactam, benzoxazin-type activators, peroxyacid activators having an amide moiety, and mixtures thereof.
17. A method according to Claim 15 wherein the aqueous liquor has a pH of 7.0 to 10.5, and further comprises conventional detergent ingredients.
18. A method according to Claim 17 wherein the conventional detergent ingredients comprise from 5% to 80% by weight of a deterative surfactant, from 5% to 80% by weight of a detergent builder, and from 0% to 20% by weight of conventional deterative adjunct materials.

19. A method for cleaning fabrics in washing machines having parts made of natural rubber which is susceptible to oxidative degradation, said method comprising agitating said fabrics in an aqueous liquor comprising a bleaching system according to Claim 1 such that said natural rubber parts of said machine are substantially undamaged by the bleaching system.

## INTERNATIONAL SEARCH REPORT

 Interna Application No  
 PCT/US 94/05368

 A. CLASSIFICATION OF SUBJECT MATTER  
 IPC 5 C07D223/10 C11D3/39 D06L3/02

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

 Minimum documentation searched (classification system followed by classification symbols)  
 IPC 5 C07D C11D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	FR,A,2 388 924 (BOSCH-SIEMENS HAUSGERÄTE GMBH) 24 November 1978 see the whole document, particularly claim 3 ---	1-19
X	CHEMICAL ABSTRACTS, vol. 66, no. 16, 17 April 1967, Columbus, Ohio, US; abstract no. 65893a, J. STEHLICEK ET AL 'Alkaline polymerization of 6-caprolactam. XXV. The effect of structure of the acyl on polymerization activated by acylcaprolactams or diacylamines' page 6226 ; see abstract & COLLECTION CZECH. CHEM. COMMUN. vol. 32, no. 2, 1967 pages 545 - 557 --- -/--	1-3

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

## \* Special categories of cited documents :

- "A" document defining the general state of the art which is not considered to be of particular relevance  
 "E" earlier document but published on or after the international filing date  
 "I" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)  
 "O" document referring to an oral disclosure, use, exhibition or other means  
 "P" document published prior to the international filing date but later than the priority date claimed

- "I" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention  
 "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone  
 "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.  
 "&" document member of the same patent family

Date of the actual completion of the international search

12 September 1994

Date of mailing of the international search report

20. 09. 94

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## INTERNATIONAL SEARCH REPORT

Intern al Application No

PCT/US 94/05368

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	CHEMICAL ABSTRACTS, vol. 64, no. 4, 14 February 1966, Columbus, Ohio, US; abstract no. 4934f, B. STOLL ET AL. 'Reaction between O-methylcaprolactim ether and carboxylic acid chlorides' see abstract & HELV. CHIM. ACTA vol. 48, no. 7 , 1965 pages 1805 - 1809	1-3
X	--- CHEMICAL ABSTRACTS, vol. 61, no. 1, 6 July 1964, Columbus, Ohio, US; abstract no. 571c, L.G. DONARUMA ET AL. 'N-Acyl derivatives of epsilon-caprolactam' see abstract & J. HETEROCYCLIC CHEM. vol. 1, no. 1 , 1964 pages 48 - 50 -----	1-3

## INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 94/05368

**Box I Observations where certain claims were found unsearchable (Continuation of item 1 of first sheet)**

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:  
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:  
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:  
The number of already known substituted N-benzoyl-caprolactams covered by claims 1-3 is so large that an exhaustive International Search Report is economically not justified, see PCT Guidelines, III 2.3.
3. ☐ Claims Nos.:  
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

**Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)**

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
- ☐ No protest accompanied the payment of additional search fees.

# INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/US 94/05368

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
FR-A-2388924	24-11-78	DE-A- 2719235	09-11-78
		GB-A- 1596313	26-08-81
		SE-B- 439504	17-06-85
		SE-A- 7802908	30-10-78
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